

ABSTRACT OF THE DISCLOSURE

A punch and die tooling apparatus commonly used by metal fabricators for creating holes, passages and cavities in metal plate, the die having a unique internal bore which relieves the problem of slug pulling to ensure that a slug punched out of a metal sheet is not retained on the punch face to interfere with further operation of the apparatus. The die is provided with a substantially horizontal ridge and a corresponding horizontal land and relief space formed within the bore to facilitate tipping of the slug relative to the punch and thereby break any attachment between the slug and the punch face which causes slug pulling.